

Date: Wednesday, 02/04/2008 11:27:20 AM
 User: Julie Lecocq

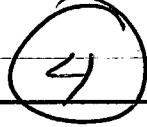
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM				
Job Number	: 38294							
Estimate Number	: 10346							
P.O. Number	:			Part Number	: D2596			
This Issue	: 02/04/2008		S.O. No. :	Drawing Number	: D2596 REV D			
Prsht Rev.	: NC			Project Number	: N/A			
First Issue	: / /		Type :	Drawing Revision	: D			
Previous Run	: 37753			Material	:			
Written By	:			Due Date	: 09/04/2008			
Checked & Approved By	: <u>JD 08.04.02</u>			Qty:	4 Um: Each			
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M							
	Est Rev:E 07-07-09 Incorporated DEO 9183 JLM							

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n - I' Beam Web 4"	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4"	
		Pick; Qty Part Number Description Batch	<i>JD 8-4-9</i>
	1 D2500-3-100 Extrusion	<u>B 33940</u>	
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr	<i>JD 8-4-9</i>
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1	<i>JD 8-4-9</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<i>8-4-11</i> 

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Skid tube cell

ST 08-04-12 X4

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15 J

Job Completion



MF 08-04-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

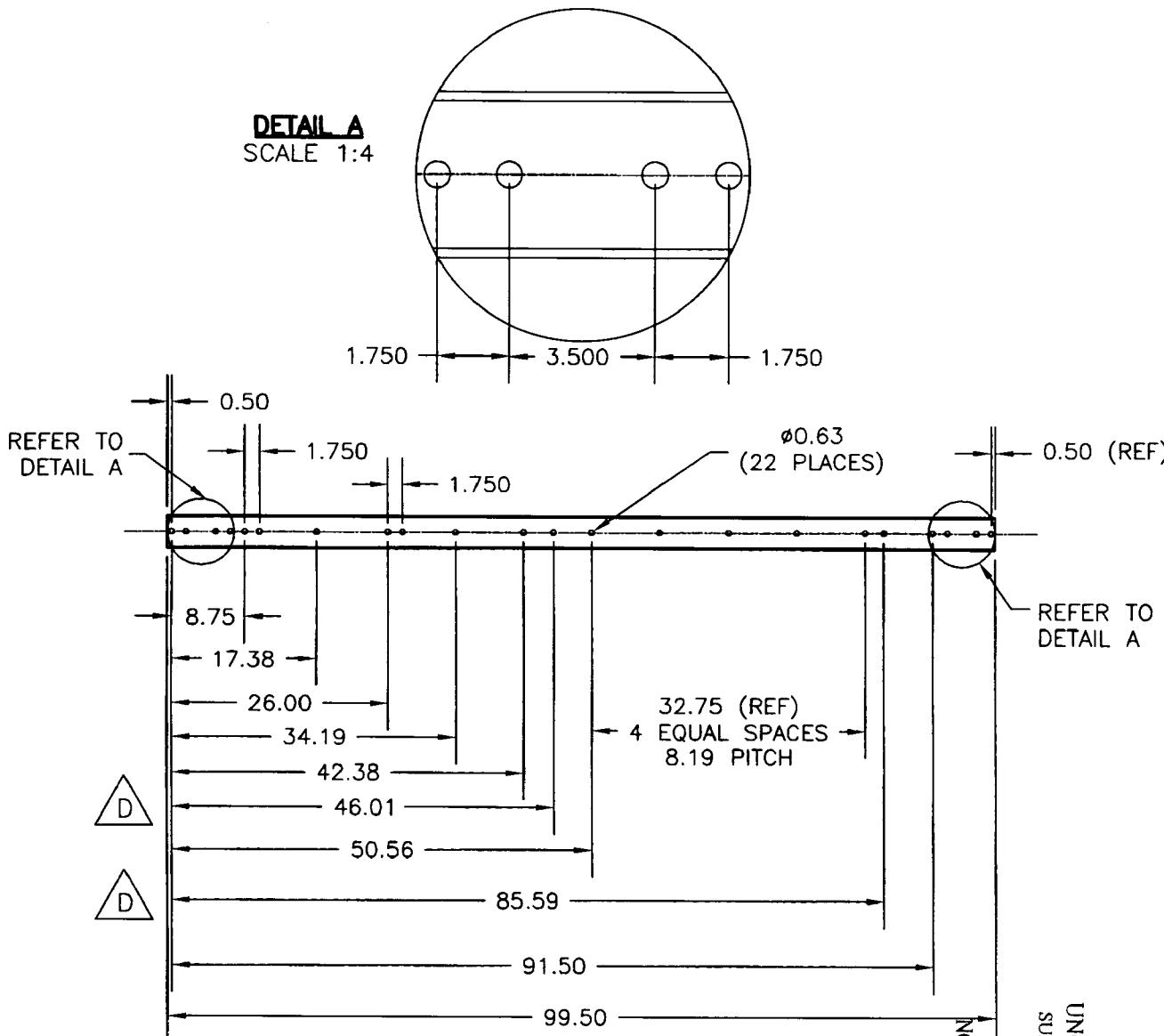
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**R
07.04.17

DESIGN <i>P4</i>	DRAWN BY <i>P4</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17	TITLE 205 WEB	SCALE 1:20	
A B C D	96.09.16 97.07.23 98.09.14 07.04.17	NEW ISSUE φ0.63 HOLE WAS φ0.56 INCORPORATED DEO 9097 INCORPORATED DEO 9183	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38294

D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020